

Work Order ID 67086

Tuesday, March 08, 2011 8:02:53 AM



Page 1

Item ID: D3589-3

Accept



Setup Start



Revision ID:

Stop



Item Name: ARM GUIDE

Start Date: 3/8/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: C2 Date: 11/03/08 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3589	Rev B

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA754 & DWG D3589

FOLIO REV: 13

DWG REV: 2

2-DEBURR AS REQUIRED

11/03/11

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11/03/11

4 9

4 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 67086

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Item ID:	D3589-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	ARM GUIDE					
Start Date:	3/8/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	3/9/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		JL 11/03/08		(4)			
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>W/D</u> Memo 65874	0.00 0.00				B	11-3-8	(K4)	
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/3/08 MF 11-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 08, 2011 8:02:49 AM

Page 1

Work Order ID: 67086

Parent Item: D3589-3

Parent Item Name: ARM GUIDE



Start Date: 3/8/2011

Required Date: 3/9/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-29 new issue DD verified by:EC iPP Rev:B
09-02-20 rev.b asper dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R.500 		Purchased	No			100	f	34.6440	0.05	0.210526			
304 SS roundbar .500													

Location

Loc Qty

Loc Code

MAT

31.134

115334

31.134

MAT029

3.51

113006

3.51

26 A

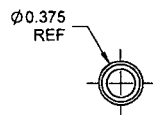
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

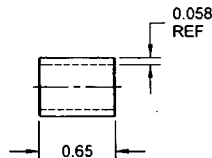
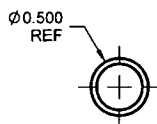


0.03 X 45°
CHAMFER
2 PL

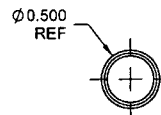


0.065
REF

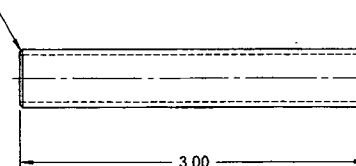
D3589-1 ARM



D3589-3 ARM GUIDE



0.03 X 45°
CHAMFER
2 PL



0.049
REF

D3589-5 LATCH GUIDE

CL 11103108
W10.67086

D3589-1/-3/-5 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
D3589-1: 0.375 O.D. X 0.065 WALL (REF. DART SPEC M304TR0.375W.065)
D3589-3: 0.500 O.D. X 0.058 WALL (REF. DART SPEC M304TR0.500W.058)
D3589-5: 0.500 O.D. X 0.049 WALL (REF. DART SPEC M304TR0.500W.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: - D3589-1 = 0.34 lbs
- D3589-3 = 0.01 lbs
- D3589-5 = 0.06 lbs

RELEASED
09/02/05

DESIGN	<i>HA</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV.
MFG. APPR.	<i>DS</i>	D3589	SHEET 4 OF 8
APPROVED	<i>HA</i>	TITLE	SCALE
DE APPR.	<i>HA</i>	LATCH ASSEMBLY	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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